

Work Order ID 77105

77105

Page 1

Friday, November 25, 2011 12:37:20 PM

Item ID: D3186-4 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacepod Door, RH
 Start Date: 11/25/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: P Date: 11-25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3186	Rev E

100 Small Fab 0.00
 100
 Small Fab Memo 0.00
 Small Fab 1-Trim door to fit spacepod before drill holes and cut out slots for latch as per
 dwg D3186 (D3186-4 detail)

BT 12-02-07

110 QC5- Inspect part completeness to step on W/O 0.00
 110
 QC Memo 0.00
 Quality Control

5/2/12

(u)

120 Identify as per dwg & Stock Location: composites 0.00
 120
 Packaging Memo 0.00
 Packaging

BT 12-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77105***77105***

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Friday, November 25, 2011 12:37:21 PM

Item ID: D3186-4

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod Door, RH

Start Date: 11/25/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/4/13 [Signature]
ME
12-04-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, November 25, 2011 12:37:25 PM

Page 1

Work Order ID: 77105

77105

Parent Item: D3186-4

D3186-4

Parent Item Name: Spacepod Door, RH

Start Date: 11/25/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-11 EC
IPP rev.B revD 07.03.07 ec
10-08-11 added trim door before drilling DD verf:EC

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2M		Manufactured	No			100	Each	0.0000	1	1			
D3186-2M									**				
SPACEPOD DOOR RH													

577107

12-02-07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

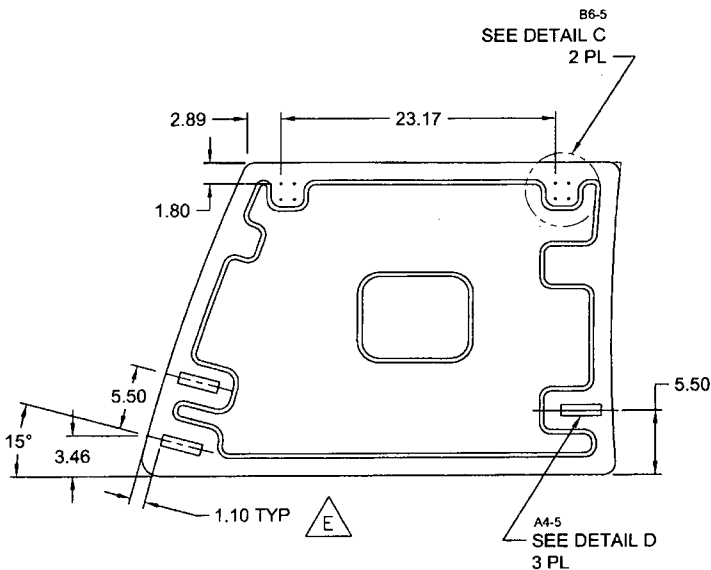
C

B

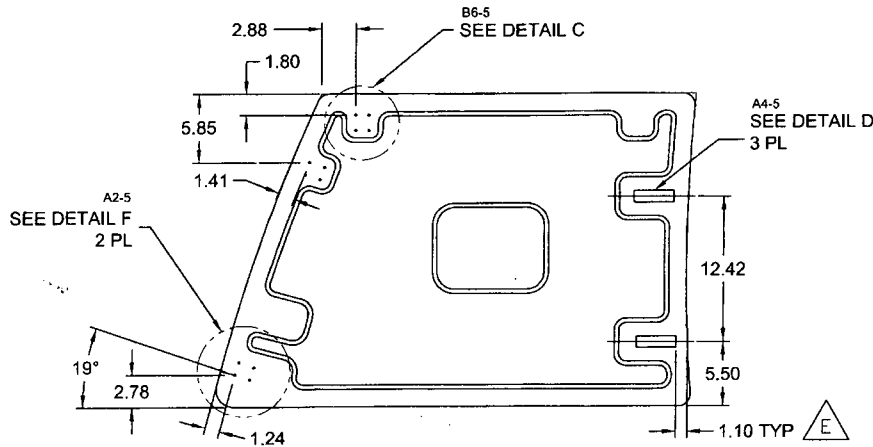
B

A

A



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M







D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71105

211-11-25

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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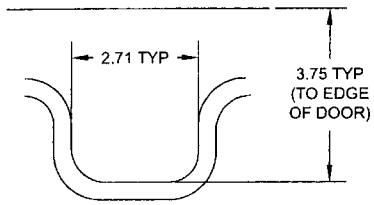
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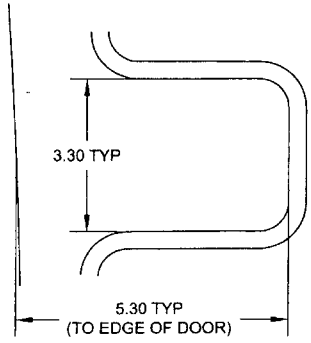
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

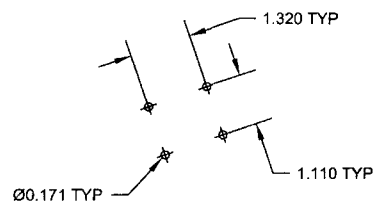
D
C
B
A



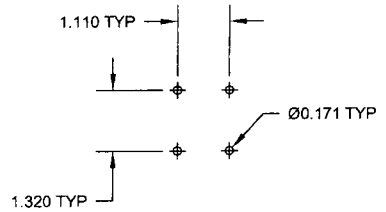
DETAIL A D6-3
SCALE 4X D4-4



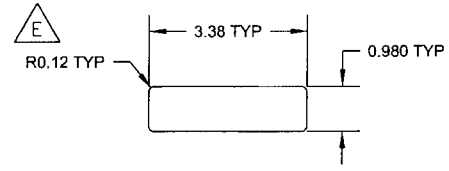
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

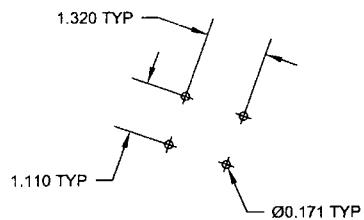


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X B6-2
C2-2



DETAIL F C4-2
SCALE 4X

17105

RELEASED
2009-09-09

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CHECKED		DRAWING NO.	REV. E
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APPROVED		TITLE	SCALE
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